

Page 1

December 7, 20	09 3:09:18 Pi	M			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	:						
Item ID:	D3775-1			A	Accept				S	etup Star	t	
Revision ID:						(Stop		
Item Name:	Guard							į		Stop		
Start Date:	07/12/2009	Start Qty: 16.0	0			Cust Item	ID:					
Required Date	: 21/12/2009	Req'd Qty: 16.0	OC.			Customer:	. ,					
Reference:								_		Ston		
Approvals:	Process Pla	n:	Date:	9-12-7	Tooling:		ate:		K	un Star		
••	QC:		Date:		SPC (Y/N):	r	Date:	1		Stop		
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr						Ť				
D3775	Rev	/ B						<u>.</u>				
100				,	0.00							
		DOOSAN LATHE						‡				
Doosan		Memo		N/A	0.00	A ===	۱ ، ، ،	aliala	V 15			
Doosan Lathe		1- Turn per dwg	as per Folio FA74 ; D3775	42 Rev: <u>N (/ - 1</u>	& Dwg D3775Rev:		<u> </u>	((like la	18 (11			
								1				
110		QC2- Inspect parts of	off machine FAI/F	FAIR	0.00	09/12/28			•			
		QC2- Mapeet parts	off macianic 17454	7115	V.V	11100						
	•	Memo			0.00				-			
Quality Control												
			,	ı								
						1						
120		QC8- Inspect parts	- second check		0.00	18 -1 1						
					2	\$P09/12/24			17			
QC		Memo			0.00	/ /			•			
Quality Control												

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	•									
W/O:			WO	RK ORDER CHA	ANGES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					24					
					•					
Part No	:	PAR #:	Fault Categ	ory:	NC	R: Yes	No DQ	A :	_ Date: _	
	Re	esolution:	Disposition	•	QA	: N/C Cld	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC	ļ. <u>.</u>	Corrective Action	Section B		Verific	ation	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Secti		Chief Eng	QC Inspector
				•						
				· ·						
									•	

Work Order ID 54313



Page 2

December 7, 2009 3:09:18 PM

Required Date: 21/12/2009

Item ID:

D3775-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

07/12/2009

Guard

Start Qty: 16.00 Req'd Qty: 16.00

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Date:

Draw

Rev.

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Plan

Code

Qty

Reject

Reject Insp. Number Stamp

Accept

Qty

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/01/0692 MF 09-12-29

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W/O:			WC	ORK ORDER CHANG	GES		<u> </u>			÷
DATE	STEP	PRO	OCEDURE CHA	NGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		•		,						9° 29
				·						- 1
	į					į				por Page
Part No	:	PAR #:	Fault Cate	gory:	NCR: \	es N	o DQ /	. i A :	Date:	
		esolution:								
NCR:			WORK ORDI	ER NON-CONFORM	IANCE (N	ICR)				
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti		Chief Eng	QC Inspector
		, , , , , , , , , , , , , , , , , , , 		,						
i.										

Picklist Print

December 7, 2009 3:09:22 PM

Work Order ID: 54313

D3775-1 Parent Item:

Parent Item Name: Guard

Comments:



Start Date: 07/12/2009

Required Date: 21/12/2009

Page 1

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRINR1.500		Purchased	No	-		100	f	33.0000	3.9579			

Inventory

Warehouse	Loc Qty	Loc Code
Location		,
Main Warehouse		
MAT	33	
107961	4.01	
110115	10.9	
110255	18.09	

3.758 JL 10/01/06

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W/O:			WC	RK ORDER CHANG	ES	<u></u>				
DATE	STEP	PRO	OCEDURE CHA	NGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•			1978							
Part No	•	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	o DQ	A :	Date:	
	R	esolution:	Disposition	າ:	_ QA: N	/C Clos	sed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)	-			
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
		,								
	:					- 				
						,		_		
					į					

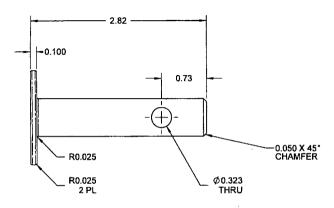
DART AEROSPACE LTD	Work Order:	543/3
Description: Guard	Part Number:	D3775-1
Inspection Dwg: D3775 Rev: B		Page 1 of 1

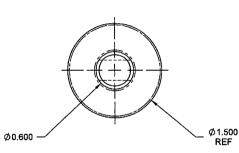
FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le	Proto	type			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Metho Inspe		Com	nments
2.82	+/-0.030	2.821						
0.100	+/-0.010	-101						
0.73	+/-0.030	1730						
0.050 x 45°	+/-0.010 x 0.5°	.050x45°	/_					
R0.025	+/-0.010	.025						
Ø0.323	+0.006/-0.001	-322						
Ø0.600	+/-0.010	.603						· · · · · · · · · · · · · · · · · · ·
Ø1.500	+/-0.010	1.503	V					
								<u> </u>
							_	
								. <u></u>
	·							
								·····
Measured by:		Audited by:	SP		Proto	type A	pproval:	N/A
Date:	09/12/28	Date:	09/12/2	8			Date:	N/A
Rev Date	Change		/ /				ed by	Approved
A 08.09.04	New Issue					KJ/DI) of	N/

Dart Aerospace L	∟td
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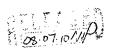
										
W/O:			W	ORK ORDER CI	HANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										. /
				,						
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes 1	lo DQA:		_ Date: _	
	R	esolution:	Dispositi	on:	QA	: N/C Clo	sed:		Date:	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORE	DER NON-CONF	ORMANCE	(NCR)			orane.	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descr	Section B iption	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
										
								,		
·			,							





SHOP COTY RETURN 10 **ENGINEERING** UNCONTROLLED COPT SUBJECT TO AMENDA: WITHOUT NOTICE WORK ORDER NO. 54313 MOS-12-7

D3775-1 GUARD /B



В	RE-DES	IGN -1 FOR LO	NGER PROFILE, ELIMINATE -3	HS	08,06.10	
Α	NEW IS	SUE		HS	08.06.04	
REV.			DESCRIPTION	BY	DATE	
DESIGN	1	HS	DART AEROSP	ACE L	TD	
DRAWN	1	HS	HAWKESBURY, ONTA		. –	Ι΄
CHECK	ED	B /	DRAWING NO.		REV. B	
MFG. A	PPR.	C./uld	D3775		SHEET 1 OF 1	
APPRO	VED		TITLE		SCALE	
DE APP	PR.	AF-	GUARD		NTS	ı
DATE	08.0	6.10	COPYRIGHT © 2008 BY DAR THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATION.	LEO OH THE EXPRES	S CONDITION THAT IT IS	

VOTES:
|) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR (REF. DART SPEC. M-DELRIN-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
3) IDENTIFICATION: N/A

') WEIGHT: 0.03 lbs

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W/O:			W	ORK ORDER CHANG	SES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		•			•					
Part No	:	PAR #:	Fault Category:			NCR: Yes No DQA: Date:				
	Re	esolution:	Disposition:			N/C Clo	sed:	Date:		
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section			Verifica			ntion Approval	Approval
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
•										
										